

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000119**Date Inspected:** 28-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, California**CWI Name:** Bernard P. Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record Test**Summary of Items Observed:**

1) ABF Welding Superintendent Mr. Tommy Gibson is present during the attempt of procedure qualification record (PQR) testing.

2) Today's observations are a continuance of procedure qualification record test attempt for PQR test identified as ABF-PQR-002-1. This is the third attempt of this PQR test.

3) The Caltrans QA Inspector observed a total of nine flux cored arc welding passes applied to the PQR test plate assembly. Six of the nine FCAW passes contained visual discrepancies consisting of non-uniform weld profiles, overlap and excessive reinforcement. The welder was observed grinding these weld passes to a bright flush condition prior to applying subsequent weld passes. Only weld passes five, six and seven were observed as visually compliant and did not have any significant grinding performed.

Mr. Tommy Gibson terminated the witnessing of this PQR test prior to its completion at approximately 1500.

Although this PQR test is incomplete, the Caltrans QA Inspector observed that this PQR test is a significant improvement from previous observations noted on dates 03-26-2007 and 03-27-2007.

For specific welding parameter values recorded during this procedure qualification record test see the Caltrans TL-6032 generated for this date. Digital pictures that support today's observations are included within the TL-6032.

Summary of Conversations:

Mr. Tommy Gibson voiced that ABF would resume the welding of this PQR test plate assembly on Thursday 03-29-2007.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

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for your project.

Inspected By: Cuellar,Robert

Quality Assurance Inspector

Reviewed By: Smith,Ryan

QA Reviewer